

# Work Order ID 67332

Tuesday, March 15, 2011 10:47:04 AM



ship Friday Page 1

Item ID: D3340-7

Accept



Setup Start



Revision ID:

Item Name: Fwd Skidtube Protector

Stop



Start Date: 3/15/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/17/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: 11-03-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID  
Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3340

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3340 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Deburr if necessary

*W* 11 03 15 (4)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*W* 11 03 15 (4)

120

0.00



QC8- Inspect parts - second check

QC

Memo 54-03

0.00

Quality Control

EO 11

4 11-03-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




# Work Order ID 67332

Tuesday, March 15, 2011 10:47:04 AM

Page 2

Item ID: D3340-7	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Fwd Skidtube Protector					
Start Date: 3/15/2011	Start Qty: 4.00		Cust Item ID:		
Required Date: 3/17/2011	Req'd Qty: 4.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC	NC BRAKE	0.00							
Brake NC	Memo Deburr if necessary Form on brake as per Dwg D3340 using Jigs DT <i>D8326</i> and DT <i>8241</i>	0.00				<i>(4)</i>			
									<i>SA 11/03/17</i>
140  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00				<i>(x4)</i>			
150  Powdercoat	Grey Sandtex(Ref:4.3 5.6) per QSI005 4.3	0.00							
Powder Coating	Memo START TIME: <i>11:50</i> DOVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>12:20</i>	0.00				<i>4</i>	<i>BL</i>	<i>11-3-17.</i>	

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**NOTE:** Date & initial all entries

**Work Order ID 67332**

Tuesday, March 15, 2011 10:47:04 AM

Page 3

Item ID: D3340-7

Accept

Setup Start

Revision ID:

Stop

Item Name: Fwd Skidtube Protector

Start Date: 3/15/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 3/17/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 0 11/03/11

170

Identify as per dwg &amp; Stock Location: 499

0.00



Packaging

Memo

0.00

Packaging

11/3/17 SF

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/18  
ME  
11-03-17

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, March 15, 2011 10:46:58 AM

Page 1

Work Order ID: 67332



Parent Item: D3340-7



Parent Item Name: Fwd Skidtube Protector


Start Date: 3/15/2011

Required Date: 3/17/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A 05.11.10 Preliminary issue AP/EC  
IPP Rev:B Now on Waterjet 06-09-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S20GA  1010/1025 SHEET		Purchased	No			100	sf	169.8000	0.889	3.743158		11-03-15	

Location

Loc Qty

Loc Code

MAT

169.8

111410

73.8

116791

96

W/O:		WORK ORDER CHANGES					
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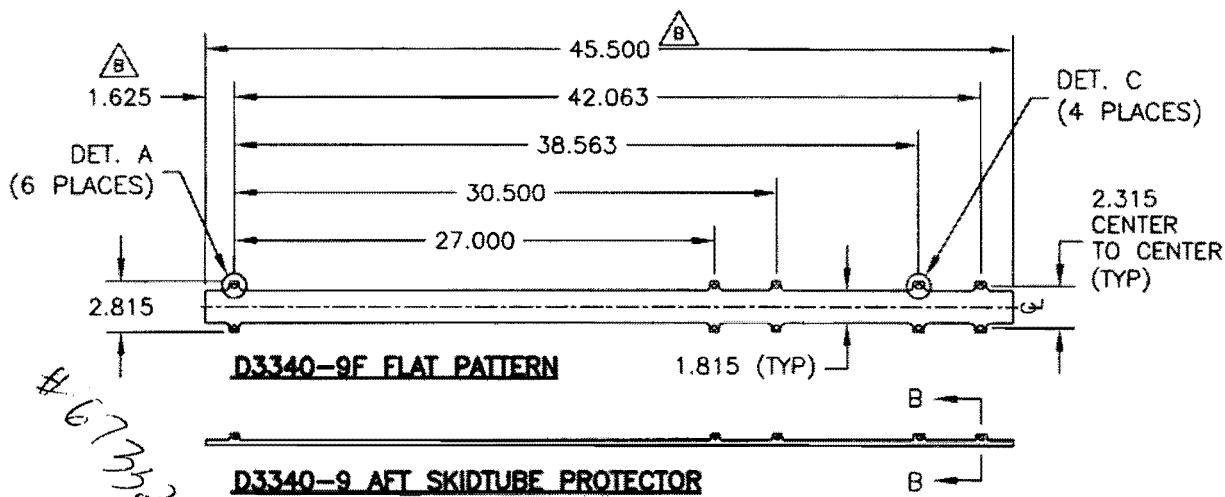
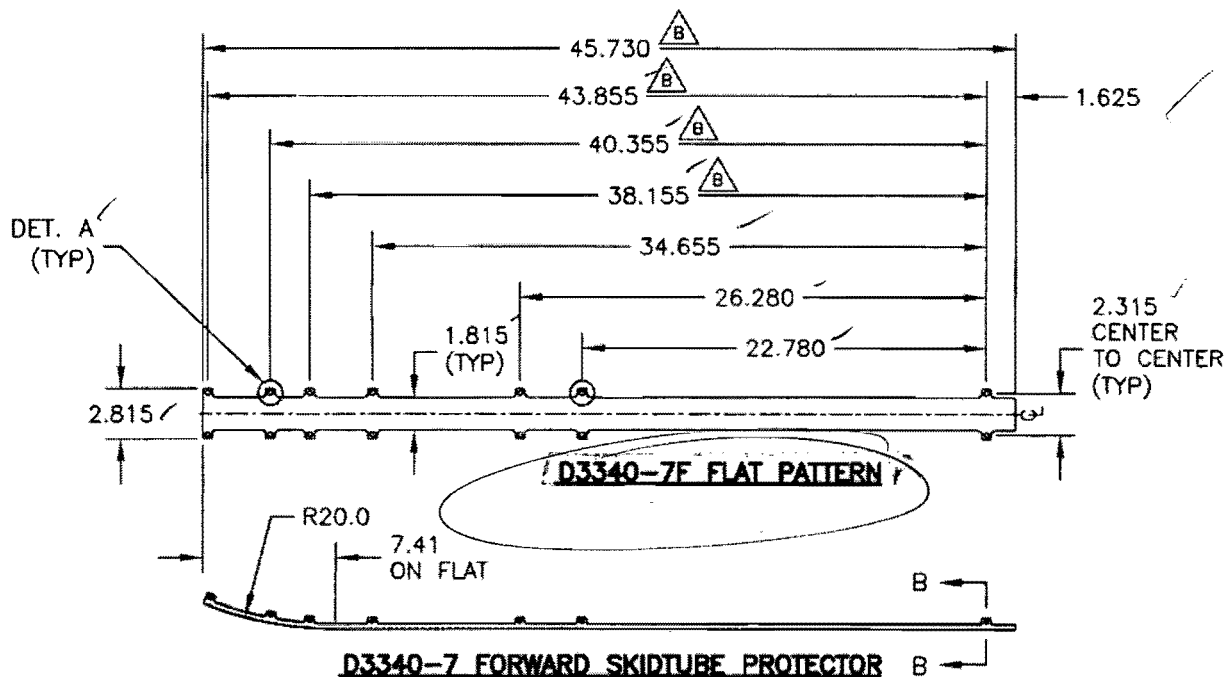
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**NOTE:** Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3340	REV. B SHEET 4 OF 11
DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

RELEASED  
05.11.28

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**Dart Aerospace Ltd**

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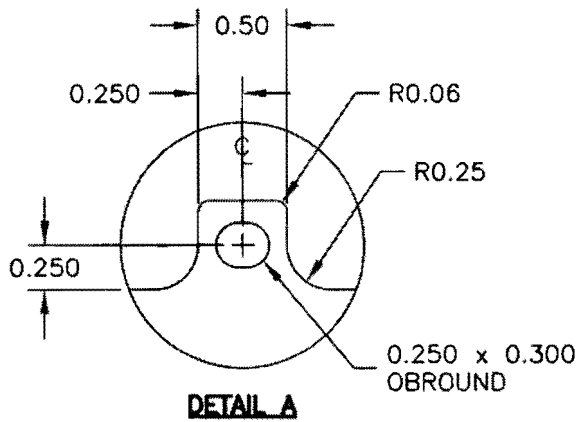
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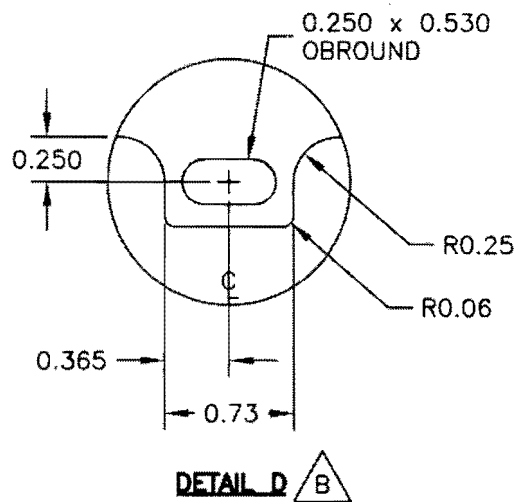
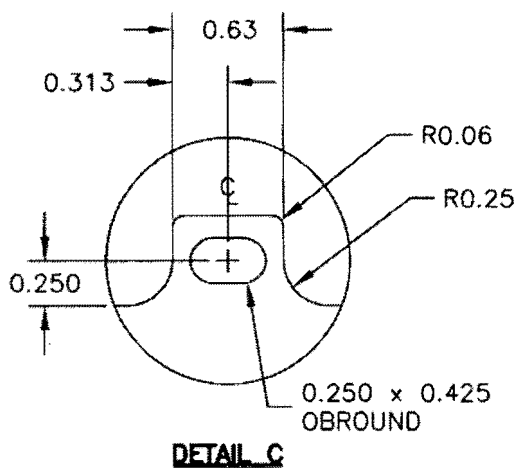
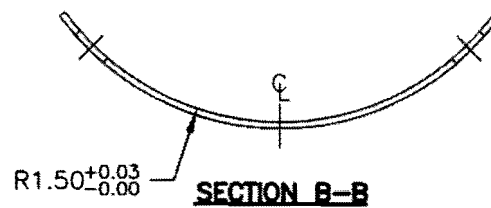
**NOTE:** Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3340	REV. 8 SHEET 11 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:1



RELEASED  
05-11-28 #



# 67252

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